Qty:

40 Um:

Each

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

: WEARPAD

: D26483

: N/A

: D

: D2648 REV D

: 29/12/2008

Thursday, 11/12/2008 10:08:13 AM

Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 43989 **Estimate Number** : 10313

P.O. Number

This Issue : 11/12/2008

: NC Prsht Rev.

: // First Issue

: 43848 **Previous Run**

Written By

Checked & Approved By

Comment

S.O. No. :

Type

Est Rev:F Now on Waterjet 06-08-14

: SMALL /MED FAB

Re-format; Incorporated D2648-1 KJ/RF

Material

Due Date

Description:

1010/1025 sheet 16GA

JLM

Additional Product

Job Number:



Seq. #: 1.0

Machine Or Operation:

M1010S16GA

Comment: Qty.: 0.0788 sf(s)/Unit

Total: 3.1500 sf(s)

1010/1025/A21/6aA SHEET

(M1010S16GA)

Batch: (65766)

2.0



FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2648

Dwg Rev:_

Prog Rev:_

B9-1-6

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



B9-1-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

Page 1

QC8

SECOND CHECK



Comment: SECOND CHECK

SMALL FAB 1 5.0

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL

Deburr if necessary





Form: rprocess

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE By Date				Approval Chief Eng / Prod Mgr	Approval QC Inspector					
		$\mathbf{A}_{\mathbf{A}}(\mathbf{x})$										

Part No: D2648.3 PAR #: NA Fault Category: Prod Fors. NS Med Sm. NCR: Yes No DQA: Date: 09/00/04

Resolution: SCIPP Disposition: SCIPP QA: N/C Closed: D Date: 09/00/04

3989	We	ORK OR	DER NON-CONFORMANCE	(NCR)			•
	Description of NC		Corrective Action Section B	Verification	Ammrayal	Approval	
	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
20	Part.	rosour	Scrap and Destroy aty (P) AD Replace. Qty & B# M10576	1B 91-4	09/61/06	OSKUM	કરી <i>ના જિ</i>
	R.C. water set malfuction.					, -	,
					,	·	
	STEP	Description of NC Section A Durry enspection Of Y (P) Port has a small cut out en the missee middle of the Part.	Description of NC Section A Durring enspection Of Y (1) Fort has a small cut out en the missele mulle of the Part. Part.	STEP Description of NC Section A Initial Chief Eng Durking expection Oby (P) Port has a small cut out in the missible meldle of the Part. R.C. water yet mal fuction. Corrective Action Section B Initial Chief Eng Scrap and Destroy Oby (P) Are Replace. Oby (P) By M10576	STEP Description of NC Section A Initial Chief Egg Durring enspect in Oly (P) Fourth has a small cut out in the missiste multle of the Part. Action Description Chief Egg Scarp and Destry Oly (P) Are Replace. Oly (R) BY MID 576	STEP Description of NC Section A Initial Chief Eng Corrective Action Section B Verification Section C Sec	STEP Description of NC Section A Initial Chief Egg Durring enspect in Oty (1) Pour has a small cut out in the missake malike of the Pat. By M10576 Corrective Action Section B Verification Section C Section C Approval Chief Eng Scrap and Destry and (1) Are Replace. Only (2) By M10576 Corrective Action Section B Verification Section C Section C Approval Chief Eng Corrective Action Description Section B Verification Section C Section C Section C Section C Chief Eng Scrap and Destry and (1) Are Replace. Only (2) By M10576

NOTE: Date & initial all entries

Thursday, 11/12/2008 10:08:13 AM Date: Julie Dawson User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: WEARPAD** Job Number: 43989 Part Number: D26483 Job Number: Seq. #: Description: Machine Or Operation: NC BRAKE **BRAKE NC** 6.0 Comment: NC BRAKE 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D2648-3 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 7.0 Comment: LARGE FABRICATION RESOURCE 1 Batch Qty Description M/09479 A/R560Hardcoat 1-Weld as per Dwg D2648 using Jig DT 8210 2-Remove any weld that penetrated through Wearpadif necessary VISUAL INSPECTION OF GROUND WELDS 8.0 QC10 Comment: VISUAL INSPECTION OF GROUND WELDS INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 10.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: **OVEN TEMPERATURE:** FINISH TIME: 11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING RESOURCE #1 12.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:

Dart Aerospace Ltd

W/O:	· ·		WO	RK ORDER CHANG	SES				
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					· · · · · · · · · · · · · · · · · · ·			i rou ingi	
]
Part No	ŧ	PAR #:	Fault Cate	jory:	NCR: Ye	s No D	QA:	Date: _	. <u> </u>
	Re	esolution: Disposition: Q				Closed: _		Date: _	.
NCR:		1	WORK ORDE	R NON-CONFORM	ANCE (NO	CR)			
	0750	Description of NC	Description of NC Corrective Action - S			Ver	erification Approva	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& ∣ _{Se}	Section C	Chief Eng	QC Inspector
				ı					

NOTE: Date & initial all entries

Date: User:

Thursday, 11/12/2008 10:08:13 AM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 43989

Part Number: D26483

Job Number:

Seq. #:

Machine Or Operation:

Description:

13.0

QC21

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.02.04

Dart Aerospace Ltd

W/O:	<u> </u>		ŴĊ	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							ļ		
· .									
									·
Part No: PAR #:			,	Fault Category: NCR: Yes No DQA:					
Resolution: Disposition			າ:	QA: N/C CI	osed:		Date: _		
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Description of NC Corrective Action				Verification		Approval
	012.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	on C	Chief Eng	QC Inspector
									}
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				Participation and					
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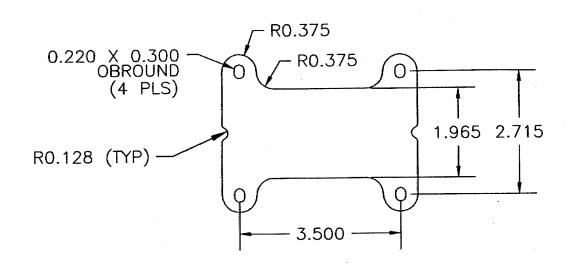
NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 4 518	
Description: Wearpad	Part Number: D2648	-3
Inspection Dwg: D2648 Rev: D	Page 1	of 1

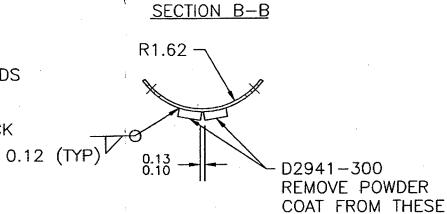
	FI	RST .	ARTICLE IN	SPECTIO	ON CHE	CKLIST		
		X	First Articl	е 🗌	Protot	ype		•
Drawing Dimension	Toleranc	е	Actual Dimension	Accept	Reject	Method of Inspection		mments
1.965	+/-0.010)	1.964	×				
2.715	+/-0.010)	2714	×				
3.500	+/-0.010		3,498	*				
0.220 x 0.300	+/-0.010 x +/-	0.010	224830	×				
R0.375	+/-0.010)	375	×				
R0.128	+/-0.010		861.	×				
£40,	4010		,061	×				
				`				
		•						
					. •	•		
				1				
						;		
Measured by:	_a D		Audited by:			Prototype	Approval:	N/A
	IB (a)			20/2	161	Fiolotype	————— -	
Date:	9-1-6		Date:	09/0	1/06		Date:	N/A
Rev Date	Change						Revised by	Approvød

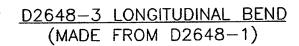
Rev	Date	Change	R	Revised by	Approved
Α	06.10.16	New Issue		KJ/JLM A	
				7 77	7,01

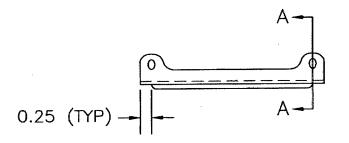
D2648-1 FLAT PATTERN



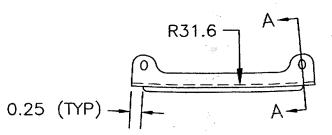
SECTION A-A R1.62 -7560 HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.063 TO 0.125 THICK



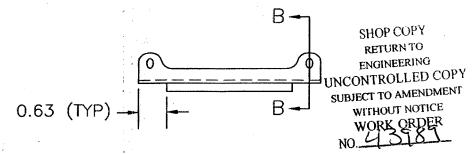


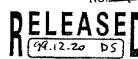


D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)





SURFACES



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

		:	
D		99.11.17	ADDED D2648-7
С		97.06.26	R31.6 WAS R19.6
В		97.05.30	ENLARGE OBROUND, 0.375 WAS 0.250
Α		97.03.25	NEW ISSUE
DESIG	Ä	DRAWN BY	DART DART AEROSPACE USA, INC.
CHECK	(ED	APPROVED	DRAWING NO. REV. D
4	壯	* At	D2648 SHEET 1 OF 1
DATE			TITLE SCALE
99.1	1.17		WEARPAD 1:2